through a 0.9 mm injection cannula. When the gel was injected into water, the gel did not spontaneously mix with water, but remained visually distinguishable.

What is claimed is:

1. An abuse-proofed, thermoformed dosage form comprising one or more active ingredients with abuse potential (A) optionally together with physiologically acceptable auxiliary substances (B), at least one synthetic or natural polymer (C), wherein the polymer (C) has a molecular weight of at least 0.5 million according to rheological measurements, and optionally at least one wax (D), wherein the dosage form exhibits a breaking strength of at least 500 N.

2. A dosage form according to claim **1**, which is in the form of a tablet.

3. A dosage form according to claim **1**, which is in multiparticulate form.

4. A dosage form according to claim **1**, wherein the polymer (C) is at least one polymer selected from the group consisting of polyethylene oxide, polymethylene oxide, polypropylene oxide, polyethylene, polypropylene, polyvinyl chloride, polycarbonate, polystyrene, polyacrylate, copolymers and the mixtures thereof.

5. A dosage form according to claim **1**, wherein the molecular weight is 1-15 million.

6. A dosage form according to claim **1**, which comprises the wax (D) and the wax (D) is at least one natural, semisynthetic or synthetic wax with a softening point of at least 60° C.

7. A dosage form according to claim **6**, wherein the wax (D) is carnauba wax or beeswax.

8. A dosage form according to claim **1**, wherein the active ingredient (A) is at least one active ingredient selected from the group consisting of opiates, opioids, tranquillisers, stimulants, barbiturates and further narcotics.

9. A dosage form according to claim **1**, which additionally comprises at least one of the following components a)-f):

(a) at least one substance which irritates the nasal passages and/or pharynx,

(b) at least one viscosity-increasing agent, which, with the assistance of a necessary minimum quantity of an aqueous liquid, forms a gel with the extract obtained from the dosage form, which gel optionally remains visually distinguishable when introduced into a further quantity of an aqueous liquid,

c) at least one antagonist for the active ingredient or active ingredients with abuse potential,

(d) at least one emetic,

(e) at least one dye as an aversive agent,

(f) at least one bitter substance.

10. A dosage form according to claim **9**, wherein the component (a) irritant substance causes burning, itching, an urge to sneeze, increased formation of secretions or a combination of at least two of these stimuli.

11. A dosage form according to claim **10**, wherein the component (a) irritant substance is based on one or more constituents of at least one hot substance drug.

12. A dosage form according to claim **11**, wherein the hot substance drug is at least one drug selected from the group consisting of Allii sativi bulbus (garlic), Asari rhizoma cum herba (Asarum root and leaves), Calami rhizoma (calamus root), Capsici fructus (capsicum), Capsici fructus acer (cayenne pepper), Curcumae longae rhizoma (turmeric root), Curcumae xanthorrhizae rhizoma (Javanese turmeric root), Galangae rhizoma (galangal root), Myristicae semen (nutmeg), Piperis nigri fructus (pepper), Sinapis albae semen (erucae/white mustard seed), Sinapis nigri semen (black mustard seed), Zedoariae rhizoma (zedoary root) and Zingiberis rhizoma (ginger root).

13. A dosage form according to claim **11**, wherein the constituent of the hot substance drug is an o-methoxy(methyl)phenol compound, an acid amide compound, a mustard oil or a sulfide compound or is derived from such a compound.

14. A dosage form according to claim **11**, wherein the constituent of the hot substance drug is at least one constituent selected from the group consisting of myristicin, elemicin, isoeugenol, β-asarone, safrole, gingerols, xanthorrhizol, capsaicinoids, piperine, glucosinolates, and a compound derived from these constituents.

15. A dosage form according to claim **9**, wherein component (b) is at least one viscosity-increasing agent selected from the group consisting of microcrystalline cellulose with 11 wt. % carboxymethylcellulose sodium (Avicel® RC **591**), carboxymethylcellulose sodium (Blanose®, CMC-Na C**300**P®, Frimulsion BLC-**5**®, Tylose C**300** P®), polyacrylic acid (Carbopol® **980** NF, Carbopol® **981**), locust bean flour (Cesagum® LA-**200**, Cesagum® LID/**150**, Cesagum® LN-**1**), citrus pectin (Cesapectin® HM Medium Rapid Set), waxy maize starch (C*Gel **042010**®), sodium alginate (Frimulsion ALG (E**401**)®), guar flour (Frimulsion BM®, Polygum **26**/**1**-**75**®), iota carrageen (Frimulsion D**021**®), karaya gum, gellan gum (Kelcogel F®, Kelcogel LT**100**®), galactomannan (Meyprogat **150** ®), tara bean flour (Polygum **43**/**1**®), propylene glycol alginate (Protanal-Ester SD-LB®), sodium hyaluronate, apple pectin, pectin from lemon peel, sodium hyaluronate, tragacanth, tara gum (Vidogum SP **200**®), fermented polysaccharide welan gum (K**1**A**96**) and xanthan gum (Xantural **180**®).

16. A dosage form according to claim **9**, wherein component (c) is at least one opiate or opioid antagonist selected from the group consisting of naloxone, naltrexone, nalmefene, nalid, nalmexone, nalorphine, naluphine and a corresponding physiologically acceptable compound.

17. A dosage form according to claim **9**, wherein component (c) is at least one neuroleptic stimulant antagonist.

18. A dosage form according to claim **9**, wherein component (d) emetic is based on one or more constituents of radix ipecacuanha (ipecac root) and/or is apomorphine.

19. A dosage form according to claim **9**, wherein component (e) is at least one physiologically acceptable dye.

20. A dosage form according to claim **9**, wherein component (f) is at least one bitter substance selected from the group consisting of aromatic oils, fruit aroma substances, denatonium benzoate and mixtures thereof.

21. A dosage form according to claim **9**, wherein the active ingredient or active ingredients (A) is/are spatially separated from component (c) and/or (d) and/or (f), wherein the active ingredient or active ingredients (A) is/are optionally present in at least one subunit (X) and components (c) and/or (d) and/or (f) is/are present in at least one subunit (Y), and, when the dosage form is correctly administered, components (c) and/or (d) and/or (f) from subunit (Y) do not exert their effect in the body and/or on taking.

22. A dosage form according to claim **1**, which comprises at least one active ingredient at least partially in controlled release form.

23. A dosage form according to claim **22**, wherein each of the active ingredients with abuse potential (A) is present in a controlled release matrix.

24. A dosage form according to claim **23**, wherein component (C) and/or component (D) also serve as a controlled release matrix material.